

Work Order ID 110579

Thursday, January 02, 2014 10:13:40 AM

110579

Page 1

Item ID: D4880-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Leg Assembly, RH
 Start Date: 1/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/31/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 1-02-02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4880	A								

110

0.00

110

Small Fab

Memo

0.00

Small Fab

ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 AND
 D4884-1. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9972 AS PER DWG.

FF
24-04-14

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

OAS
27
9-89
14/4/15

1

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Item ID: D4880-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Leg Assembly, RH
 Start Date: 1/2/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/31/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									FF
Small Fab	Memo	0.00				1			14-04-15
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9972 A/R HYSOL BATCH: M128703								
140		0.00							
140									
QC	Memo	0.00				1			
Quality Control	QC5- Inspect part completeness to step on W/O								
150		0.00							
150									
Packaging	Identify as per dwg & Stock Location: ST139B	0.00							
Packaging	Memo	0.00				1X			DAS 28 0.00 APR 16 2014

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Page 3

Item ID: D4880-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Leg Assembly, RH
Start Date: 1/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/31/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

14-4-17

14-04-16

Picklist Print

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Page 1

Work Order ID: 110579

Parent Item: D4880-042

Parent Item Name: Fwd Leg Assembly, RH

Start Date: 1/2/2014

Required Date: 1/31/2014

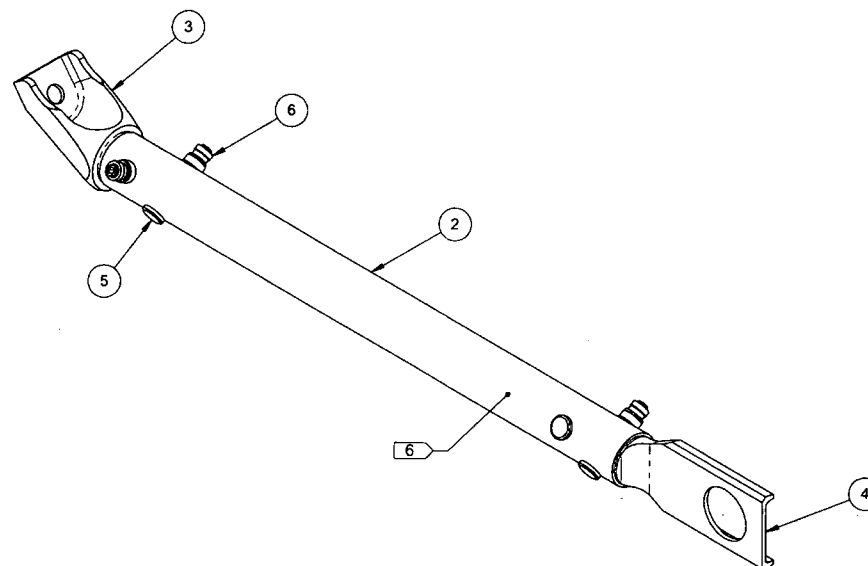
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4880-1 Strut		Manufactured	No	111338			Each	0.0000		1	FF	14-04-14	
D4883-5 End Fitting		Manufactured	No	113535			Each	0.0000		1	FF	14-04-14	
D4884-1 End Fitting, Eye		Manufactured	No	112029			Each	0.0000		1	FF	14-04-14	
HL20PB5-12 Rivet		Purchased	No	128110			Each	0.0000		4	FF	14-04-14	
HL86-5 Collar		Purchased	No	128110			Each	21.0000		4	FF	14-04-14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST283		21							
				121866		21							

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4880-041	FWD LEG ASSEMBLY, LH
2	1	D4880-1	STRUT
3	1	D4883-7	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4880-041 LEG ASSEMBLY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.65 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9971
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9971
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

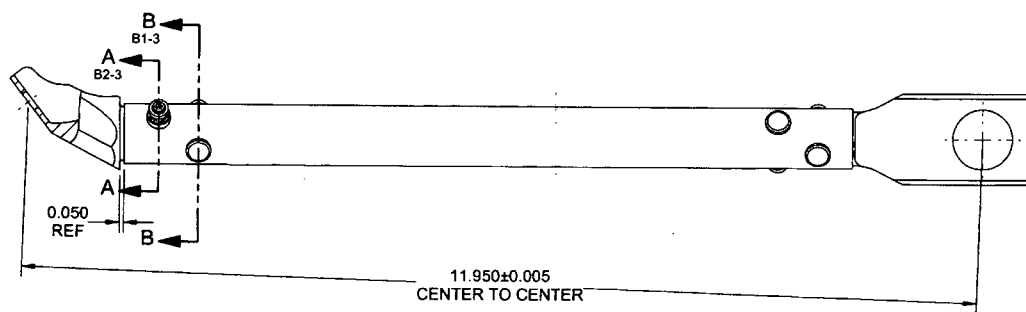
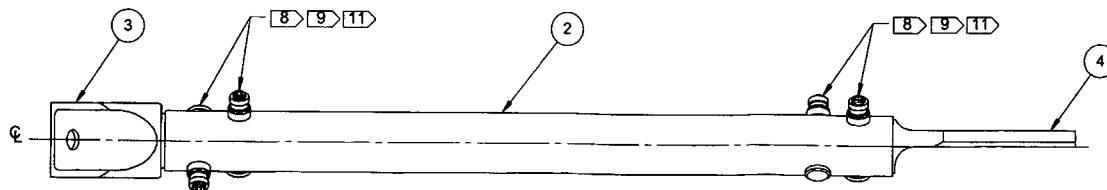
mk
14-01-02
#110579

RELEASED
2013-12-12

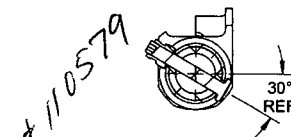
APPROVED

A		NEW ISSUE		RF	13.09.16
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4880 REV. A SHEET 1 OF 5 TITLE LEG ASSEMBLY SCALE NTS			
DRAWN	RF				
CHECKED	DC				
MFG. APPR.	JLM				
APPROVED	HS				
DE APPR.	DS				
DATE		13.12.10			

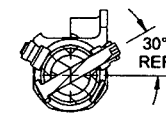
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D4880-041 LEG ASSEMBLY, LH
AUXILIARY VIEW



SECTION A-A C7-3
2 PL, SIMILAR



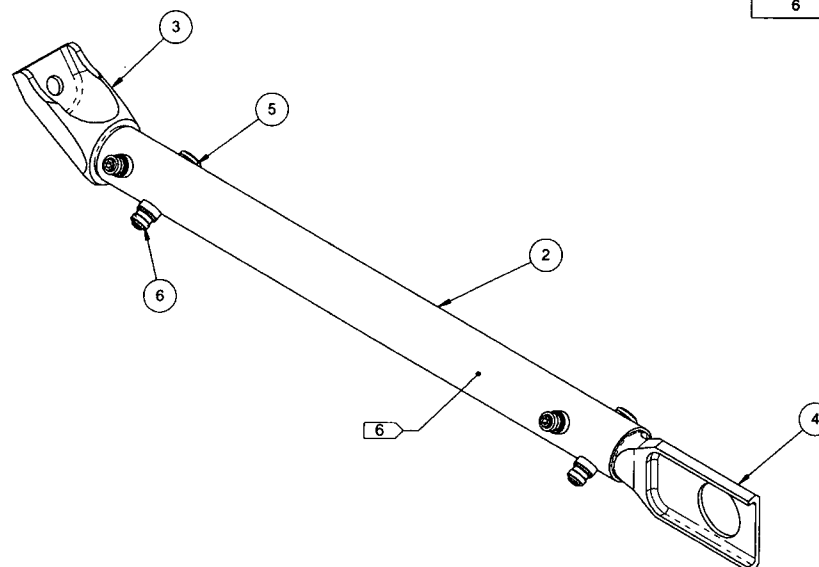
SECTION B-B C7-3
2 PL

RELEASED
2013-12-12

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4880	REV. A
MFG. APPR.	JLM	TITLE LEG ASSEMBLY	SHEET 2 OF 5
APPROVED	HS		SCALE
DE APPR.	DS		NTS
DATE	13.12.10	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4880-042	LEG ASSEMBLY, RH
2	1	D4880-1	STRUT
3	1	D4883-5	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4880-042 LEG ASSEMBLY, RH

NOTES:

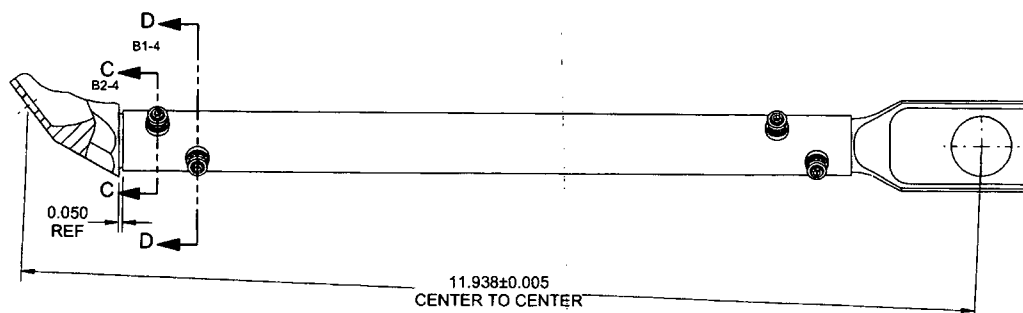
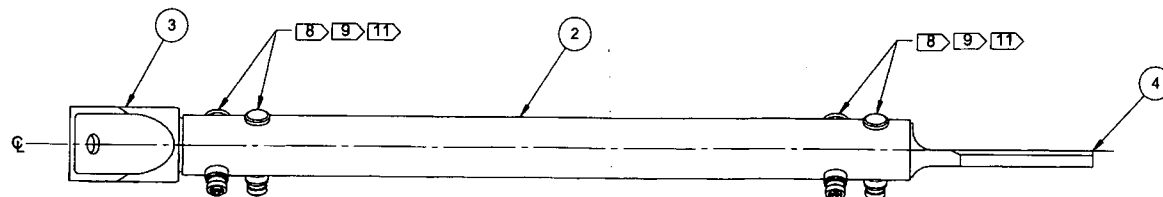
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9972
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9972
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

110579

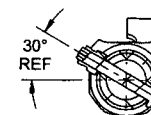
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2013-12-12

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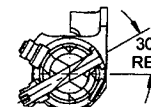
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DRAWN	RF		
CHECKED	DC	DRAWING NO. D4880	REV. A
MFG. APPR.	JLM	SHEET 3 OF 5	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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D4880-042 LEG ASSEMBLY, RH
AUXILIARY VIEW



SECTION C-C C7-4
2 PL



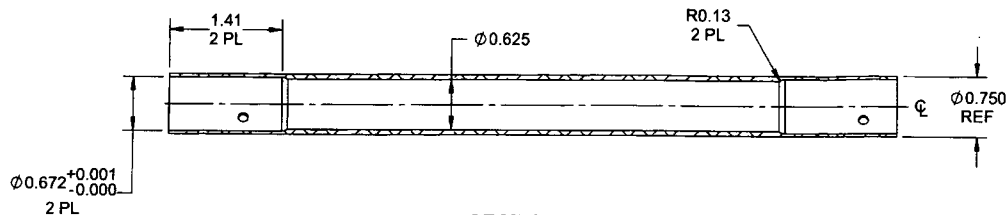
SECTION D-D C7-4
2 PL

#110579

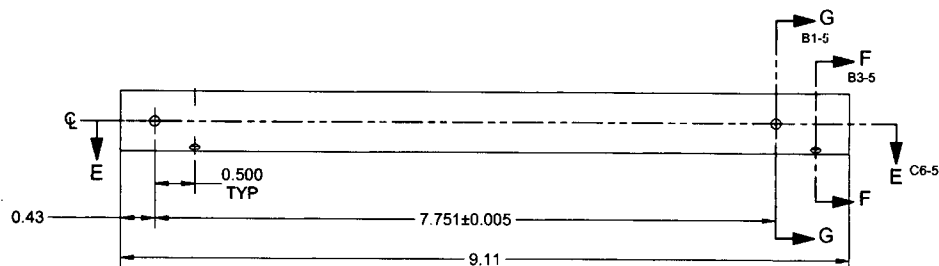
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2013-12-12

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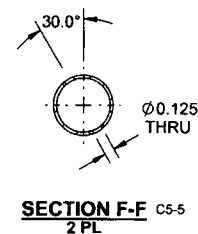
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4880	REV. A
MFG. APPR.	JLM	TITLE LEG ASSEMBLY	SHEET 4 OF 5
APPROVED	HS		SCALE
DE APPR.	DS		NTS
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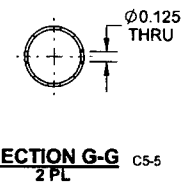
SECTION E-E B4-5



D4880-1 STRUT



SECTION F-F C5-5
2 PL



SECTION G-G C5-5
2 PL

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4880	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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2013-12-12